



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4034-041
Job Sheet 195351



Part No: D4034-041

Job Qty: 4 pcs

Part Name: Aft Upper Rib Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/17/19

Job Tracking No:

Due Date: 6/7/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEETS 1,2 IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA
10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER
DWG REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	4 pcs	6/7/19		0.00	1.60	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
110	QC 9	4 pcs	6/7/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		DAS 43
							QC 9 - 50		9-89
							QC 9 - 9		
120	QC 5	4 pcs	6/7/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		DAS 43
							QC 5 - 49		9-89
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		

Plex 5/17/19 11:21 AM Dart.lajeunesse.marie

130 Packaging 3-1 - Stock - B4B 4 pcs	6/7/19	0.00 0.00	QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	DAS
			Packaging 3 - 19 - B4B	43
			Packaging 3 - 20 - B4B	9-89
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	DAS
140 QC 21 - SA 4 pcs	6/7/19	0.00 0.00	QC 21 - SA - 21	21
			QC 21 - SA - 70	9-89
			QC 21 - SA - 53	

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: 4139840) - Assemble ribs to hoop and weld as per dwg DT9564 2- Weld
 Descriptions: bushing in rib and grind weld flush as per dwg
 110 - (QC9- Inspect visual per QSI004- Fusion Welds)
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____) LOCATION: WA004-5
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4021-7	Hoop	4 pcs (1 ea)	100-Large Fab - Basket - 1	5179339
D4021-9	Bushing	16 pcs (4 ea)	100-Large Fab - Basket - 1	5176507 x 14
D4034-1	Rib	4 pcs (1 ea)	100-Large Fab - Basket - 1	5173782 x 2
D4034-3	Rib	4 pcs (1 ea)	100-Large Fab - Basket - 1	5181499

4021-9 → 5184059 x 2

4034-1 5170939 x 2

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D4021-7	4	9	0
	D4021-9	16	46	0
	D4034-1	4	18	0
	D4034-3	4	9	0
Part Specifications				
Specifications could not be found.				

Plex 5/17/19 11:21 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY Other/Details:			



Container No: S188819



Part: D4034-041

Job No: 195351

Serial No/Batch: S188819

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/10/19